

Date: Wednesday, 3/21/2007 1:59:10 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 31401	
Estimate Number : 12801	
P.O. Number : N/A	Part Number : D35377
This Issue : 3/21/2007 S.O. No. : N/A	Drawing Number : D3537 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : NA Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 31165	Material : N/A
Written By : <u>JA 07.03.21</u>	Due Date : 3/30/2007 Qty: 10 Um: Each
Checked & Approved By : <u>JA 07.03.21</u>	
Comment : Est:Rev:A New Issue 07-03-12 ec	

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.1512 sf(s)/Unit Total : 1.5120 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: M101873

JAN 07/03/24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3537
Dwg Rev: A
Prog Rev: A

2-Deburr if necessary

JAN 07/03/24

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JAN 07/03/24

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Jan 07/03/25 (10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Deburr if necessary
Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.

SB 07/03/28

(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 1:59:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31401

Part Number: D35377

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

N/A

0703.28 (10)

(PTD)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

M02755

FC 07/04/03 (10)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/03 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/03 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 07/04/04 (10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/4/4 0

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/4/4 (10)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/04

Job Completion



07/04/04

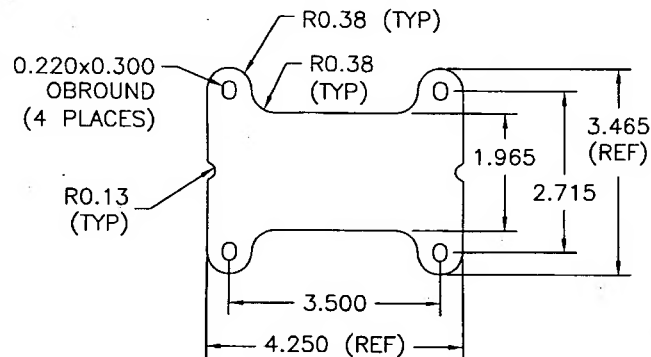
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-03-28	60	Remove Toggle. Perm. Change. <i>[Signature]</i>				<i>[Signature]</i> 07-03-28	<i>[Signature]</i> 07-03-28	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/04
 QA: N/C Closed: _____ Date: _____

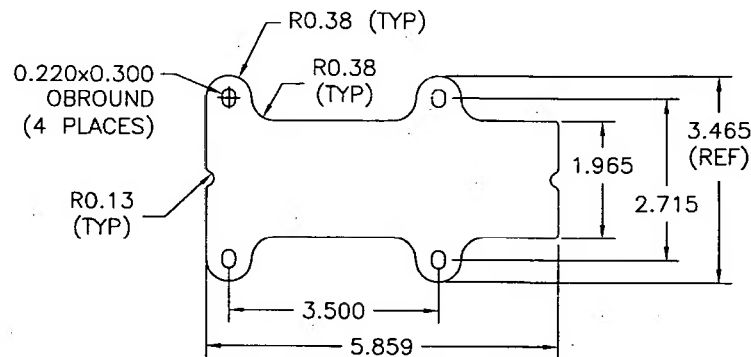
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

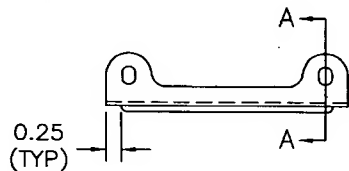
D3537-1F FLAT PATTERN



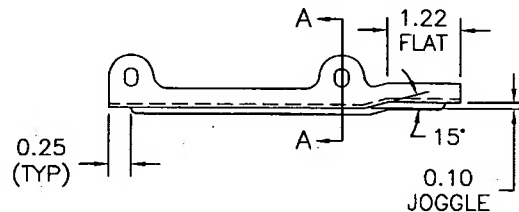
D3537-3F FLAT PATTERN



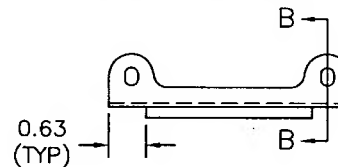
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



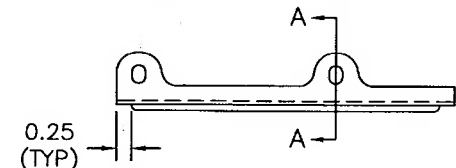
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



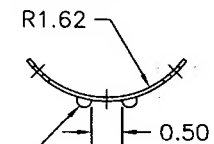
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

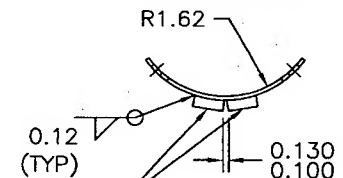


SECTION A-A



2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED

07.02.12

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE
(0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005.4.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

NO. 21401
WORK ORDER
WITHOUT NOTICE
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DART AEROSPACE USA, INC.

A	06.11.06	NEW ISSUE
DESIGN CB	DRAWN BY CB	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED PH	APPROVED	DRAWING NO. D3537 REV. A SHEET 1 OF 1
DATE 06.11.06		TITLE WEARPAD SCALE 1:2

DART AEROSPACE LTD		Work Order: 31461
Description: Wear Pad		Part Number: 035377
Inspection Dwg: 03537 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.859	+/-0.010	5.860	✓		Vern	
B	3.465	+/-0.010	3.460	✓		Vern	
C	2.715	+/-0.010	2.710	✓		Vern	
D	1.965	+/-0.010	1.971	✓		Vern	
E	0.220	+/-0.010	0.222	✓		Vern	
F	0.300	+/-0.010	0.306	✓		Vern	
G	0.063	+/-0.010	0.055	✓		Vern	
H							
I							
J							
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V							
W							
X							
Y							

Measured by: SAM	Audited by: EN	Prototype Approval:	N/A
Date: 07/03/24	Date: 07/03/24	Date:	N/A
Rev	Date	Change	Revised by Approved
		New Issue	KJ/RF

